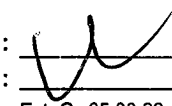
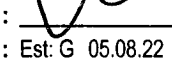


Date: Wednesday, 1/3/2007 2:53:14 PM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT CAP
Job Number :	30119		
Estimate Number :	10312		
P.O. Number :	N/A	Part Number :	D2646
This Issue :	1/3/2007	Drawing Number :	D2646 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	B
Previous Run :	28041	Material :	
Written By :		Due Date :	1/15/2007
Checked & Approved By :		Qty:	100
Comment :	Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 2785

C207101103

1-Spin as per Dwg D2646

2-Material release note required

(100)

2.0	D2646P	Aft Cap
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)
 AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

R 7/6/17 (100)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

M207/04/19 (100)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to .250" and sink as per Dwg D2646.

3-Debur

SAP 07/01/29

100 MP.

07-08-05

(999)

(PTO)

SAB

07/02/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
07-02-06	S.O.	Change the Rev. back to Rev. A to use inserts ALS4-1032-130.	PH 07-02-05			07-02-06	07-02-06

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07-02-06	S.O.	holes oversized during the C'sinking. Material is too thin for the type of insert. Back design.	QS1042	change to original Rev. A inserts as per. Drill hole & install inserts as per Rev. A. Deburr as necessary.	MF 07-02-08	07-02-06	QS1042	07-02-06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/02/14.

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 1/3/2007 2:53:14 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 30119

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SP YL

07/01/12

100

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FR/YL

07/02/13

100

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m

07/02/14

100

9.0

NAS1330C3KB116

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

NAS1330C3KB116

Insert

or ALS4-1032-130

M102475

M-R/YL

07/02/14

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

M-R/a.m

07/02/14

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07 02 14

100

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FD

M-R

07/02/14

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 1/3/2007 2:53:14 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 30119

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(100)

Comment: FINAL INSPECTION/W/O RELEASE

19/01/02/14

Job Completion



U 07.02.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

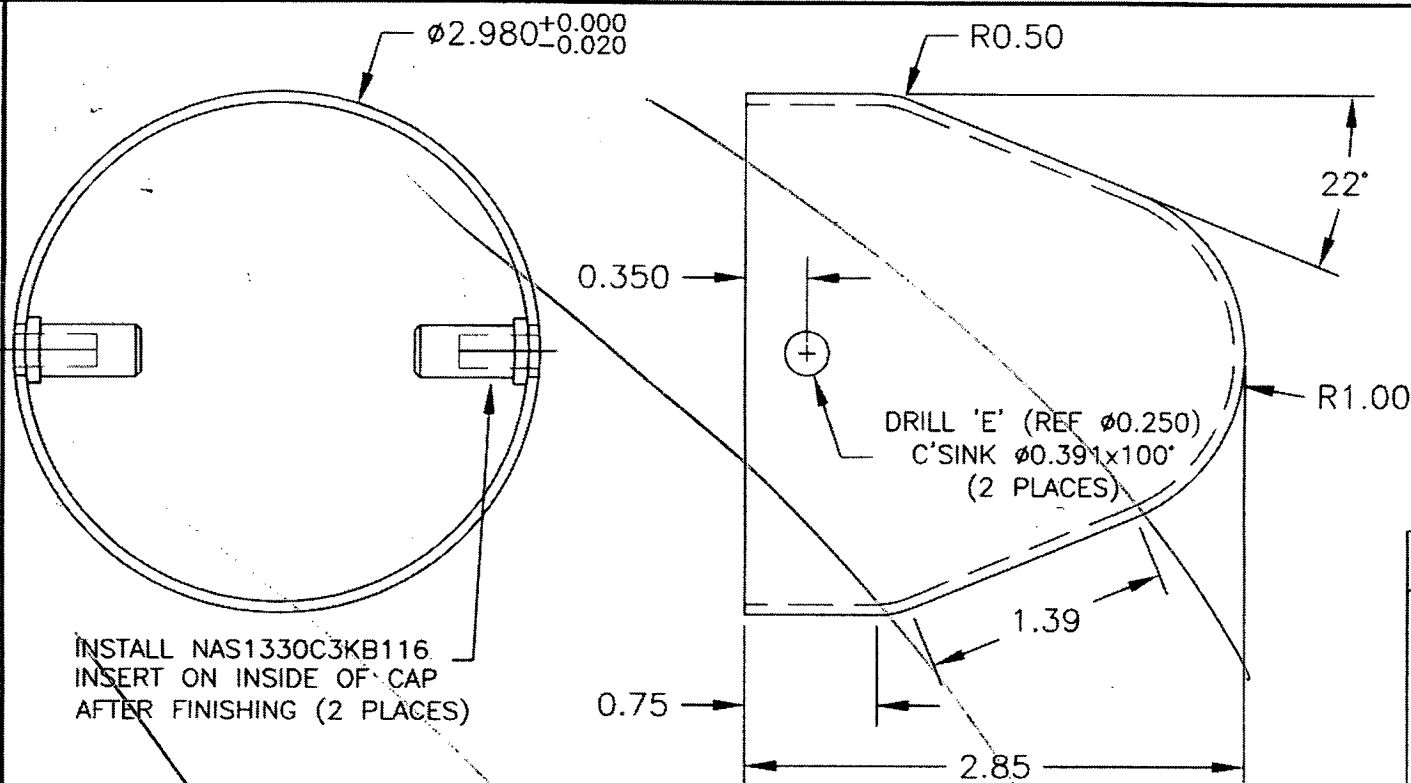
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. B
CHECKED		APPROVED		DRAWING NO.	D2646	SHEET 1 OF 1
DATE	05.04.01	TITLE	AFT CAP	SCALE	1:1	
A	97.03.25	NEW ISSUE				
B	05.04.01	CHANGE TO CLOSED INSERTS				



D2646 AFT CAP

- 1) MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-08-09

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C26710/103
w/o 30119

NOTES OF REJECT:



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO

COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS SALES INC
6555 E. DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9,760
PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792
ITEM NO	1	PART NO	050393-8
ALLOY	1100	TEMPER	O
Gauge	0.06300	WIDTH	48.0000
		FORM	COIL
		LENGTH	0.0000

MILL FINISH
NOT ANODIZE QUALITY
OUT: STANDARD MILL FINISH
IN: STANDARD MILL FINISH
NOT EMBOSSED

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JEFF FREEDY, LAB SUPERVISOR

Handwritten:
HAW
Henry @ SHZ
C/O
Sorel
LTS

15049920685

Stamps

Alcoa Sales

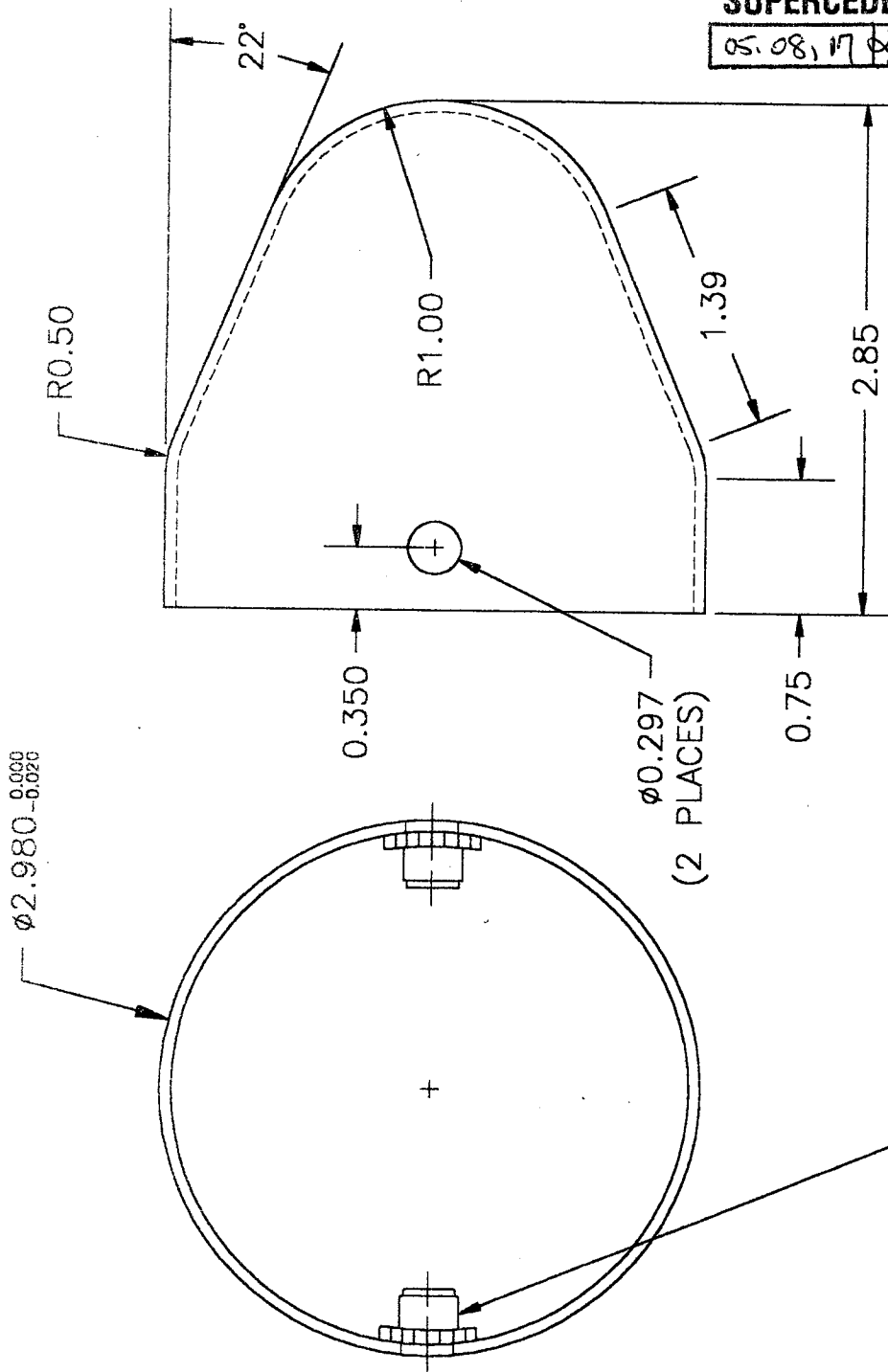


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2646	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE CAP	SCALE 1:1

SUPERCEDED BY

05.08.17 *[Signature]*

RELEASED
97/04/25 DS



INSTALL ALS4-1032-130 (OR AKS7-1032-130)
INSERT ON INSIDE OF CAP AFTER ALODINING
(2 PLACES)

MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30119